

Work Order ID 64691

Tuesday, December 14, 2010 10:41:40 AM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-12-14 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-588-011 CHG002								

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

10/12/29 sl (8)

(X8)

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Item ID: D350-588-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011

Location: 2CPPP Rev: 2C

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/11/11 SP (Signature)

11/01/12 (Signature)

MF
11-01-11

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Work Order ID: 64691

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7		Purchased	No			120	Each	108.0000	2	16			
--------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--



Screw



10/12/30 sf

Location

Loc Qty

Loc Code

ST328

108

113064

1

113749

1

114056

6

116304

100

AN526C832R8

Purchased

No



Screw

120

Each

80.0000

8



64
10/12/30 sf

Location

Loc Qty

Loc Code

ST309

80

116410

80

AN526C832R9

Purchased

No



Screw

120

Each

146.0000

8



64
M116419 10/12/30 sf 2x

Location

Loc Qty

Loc Code

ST309

100

116410

100

ST327

46

116400

46

6238

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 64691

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

AN960JD10 NAS1149D0363J Purchased No

120 Each

8.0000

4

32 30x

2x



Washer



M115107

M115622

10/12/30 SP

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8 NAS1149DN832J Purchased No

120 Each

10.0000

24

192



Washer



M116513

10/12/30 SP

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2143 Manufactured No

120 Each

10.0000

1

8



Hinge Bracket



10/12/30 SP

Location

Loc Qty

Loc Code

ST198

10

63595

10

D2144 Manufactured No

120 Each

16.0000

1

8



Hinge Bracket



10/12/30 SP

Location

Loc Qty

Loc Code

ST198

16

55179

16

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Work Order ID: 64691

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

S₄₈ D2150
Packer Doubler, Hinge

Manufactured No 120 Each 14.0000

2 16 2x
B67764 10/12/30

Location Loc Qty Loc Code

ST007 14
64309 14

S₄₈ D2151
Packer Doubler, Hinge

Manufactured No 120 Each 23.0000

2 16
10/12/30

Location Loc Qty Loc Code

ST007 23
62246 5
64310 18

S₄₈ D2153
Door Prop

Manufactured No 120 Each 30.0000

1 8
10/12/29

Location Loc Qty Loc Code

ST272 30
64311 30

S₄₈ D2154
Stud Bracket

Manufactured No 120 Each 54.0000

1 8
10/12/30

Location Loc Qty Loc Code

ST007 54
55325 1
63597 3
64312 50

3
3

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 64691

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

D2237

Manufactured No

120

Each

1.0000

2

16



Striker Plate

Location

Loc Qty

Loc Code

ST010

1

62212

1

D2461

Manufactured No

120

f

414.8900

7.25

61.05263



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

414.8900105

39782

6.5

55054

0.00001053

63880

408.39

cut 1 X 87.00"

D2463

Manufactured No

120

f

80.5205

7.25

61.05263



Seal

Location

Loc Qty

Loc Code

ST404

80.52053

55561

1.68

62597

78.84053

cut 1 X 87.00"

D2583

Manufactured No

120

Each

31.0000

2

16



Latch Bracket

Location

Loc Qty

Loc Code

ST017

29

64313

29

ST018

2

56527

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

D2585 Manufactured No 120 Each 3.0000 2



Mounting Channel

16 15x
B64655 12/12/30 sl

Location Loc Qty Loc Code

ST018 3

62676 3

D2586 Manufactured No 120 Each 0.0000 2



Door Latch

16
364656 sl

D2587 Manufactured No 120 Each 33.0000 1



Door Slug, 350 Hinge

8
12/12/30 sl

Location Loc Qty Loc Code

ST018 33

64314 33

D2589 Manufactured No 120 Each 128.0000 1



Keys, Key Chain, 350 Hinge

(with D2586)

8
12/12/30 sl

Location Loc Qty Loc Code

ST019 128

58194 128

D2690-17 Manufactured No 120 Each 8.0000 1



Cable

8
12/12/30 sl

Location Loc Qty Loc Code

ST021 8

64632 8

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

S₆ D2857-1
Hinge Bracket

Manufactured No 120 Each 4.0000

1 8
10/12/30 B64435 sl

Location Loc Qty Loc Code

ST026 4
57924 4

S₆ D2857-2
Hinge Bracket

Manufactured No 120 Each 33.0000

1 8
10/12/30 sl

Location Loc Qty Loc Code

ST025 20
ST027 33
57925 13
64463 20

S₆ D2858-1
Hinge Bracket

Manufactured No 120 Each 16.0000

1 8
10/12/30 sl

Location Loc Qty Loc Code

ST027 16
61522 5
63695 11

S₆ D2858-2
Hinge Bracket

Manufactured No 120 Each 9.0000

1 8
10/12/30 sl, ex

Location Loc Qty Loc Code

ST027 9
62020 9

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Work Order ID: 64691

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

FG-778150-550-ROL Purchased No

7781 9oz Glass 50"x125yd

Location	Loc Qty	Loc Code
ST404	1739.15	
108932	18	
111166	397	
113905	1324.15	

1- cut 1 square ft of glass cloth

MS20426AD3-4 Purchased No



RIVET

Location	Loc Qty	Loc Code
ST316	5720	
104374	1720	
110398	4000	

MS20470AD4-5 Purchased No



Rivet, Universal Head

Location	Loc Qty	Loc Code
ST309	112	
114761	112	
ST319	1500	
116410	1500	

MS21042L08 Purchased No



Nut

Location	Loc Qty	Loc Code
ST300	132	
116188	132	

1,739.150

8



10/12/29sf

5,720.000

12



10/12/30sf

1,612.000

18



10/12/30sf

132.0000

18



144 105 11/16/471 10/12/29sf 8P

39

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/15/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

MS21042L3

Purchased

No

120

Each

2,030.000

4

32



10/12/29 SP

Nut

Location

Loc Qty

Loc Code

ST300

2030

114784

34

115835

996

116373

100

116391

900

32

MS27039-08-11

Purchased

No

120

Each

95.0000

2

16



10/12/29 SP

Screw

Location

Loc Qty

Loc Code

ST290

95

116289

95

16

MS27039-1-15

Purchased

No

120

Each

98.0000

2

16



10/12/29 SP

Screw

Location

Loc Qty

Loc Code

ST292

98

114718

1

116169

97

16

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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00